

# Work Order ID 64186

Monday, November 29, 2010 3:30:40 PM



Page 1

Item ID: D2512

Accept



Setup Start



Revision ID:

Stop



Item Name: Basket Lid 205/350

Start Date: 11/29/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 12/7/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

*H*

Date:

*11/30*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2512

Rev E

100

Weld per dwg A/R S.S. rod Batch: *1114649* 0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut 3/4" x 3/4" square tubing as per Dwg D2512

2-Cut (4) D2236 From D3166-3

3-Drill holes in D2512-1 as per Dwg D2512 using Drill Jig DT8305

4-Weld as per Dwg D2512 using Welding Jig DT 9436

Deburr as required

\*\*\*INSTALL D2012-117 CLEVIS ONLY ON D130-701-041\*\*\*

*SAD 10-12-01*

*10/12/08*

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

*Pl 10-12-08*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

**Work Order ID 64186**

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Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC'6- Inspect dimensions to drawing  Memo	0.00  0.00				<i>F</i>	<i>10</i>	<i>12</i>	<i>09 (1)</i>
125  HandFinish Hand Finishing	Pressure Wash per QSI005 4.3  Memo	0.00  0.00				<i>1</i>	<i>10-12-9</i>		

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Start Date:	11/29/2010	Start Qty:	1.00			
Required Date:	12/7/2010	Req'd Qty:	1.00			
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
	<i>M115951</i>					<i>1</i>			
	Powdercoat	0.00							
	Powder Coating								
	Memo								
	1- Plug holes in D2581 and in D2327-1 bushing prior to Powdercoat								
	1ST COAT:								
	START TIME: <i>11:35</i>								
	OVEN TEMPERATURE: <i>1100</i>								
	FINISH TIME: <i>12:05</i>								
	2ND COAT:								
	START TIME: _____								
	OVEN TEMPERATURE: _____								
	FINISH TIME: _____								
	<i>N/A</i>								
140 	HandFinishing	0.00							
	HandFinish								
	Hand Finishing								
	Memo								
	Wing Walk and Spray Paint black as per Dwg D2512 and QSI 005 4.4								
	Batch: <i>M115796 SP: M115193</i>								
	<i>=&gt; ell 10/12/09</i>					<i>1</i>	<i>Ø</i>		

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Page 4

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Required Date:	12/7/2010	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00							<i>ES10/12/09</i>
160  Packaging Packaging	Identify as per dwg & Stock Location: <i>C-A</i>  Memo <i>w/o 64184</i>	0.00  0.00							<i>ES10/12/09</i>
170  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00							<i>10/12/10</i> <i>u 10.12.10</i>

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries



# Picklist Print

Monday, November 29, 2010 3:30:46 PM

Page 1  
3

Work Order ID: 64186

Parent Item: D2512

Parent Item Name: Basket Lid 205/350



Start Date: 11/29/2010

Required Date: 12/7/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: Rev IPP:M03.01.31 AddedD2012-117forD130-701-041□KJ/RF  
 IPP Rev:N□06.04.05 Added level21 EC  
 IPP REV:O ADDED D3490-1/-3 FOR D130-701-011/-043 10-04-20 JLM  
 VERIFIED BY:DD  
 IPP Rev:P 08-08-29 revE as per dwg DD verified by:EC  
 IPP Rev:Q 08-09-24 plug holes prior to powder coating DD verified  
 by:EC IPP Rev:R 10.06.29  
 added pressure wash DI) verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2012-117 		Manufactured	No			100	Each	28.0000	2	2			
Clevis													

Location	Loc Qty	Loc Code
WA	28	
3091	1	
55729	27	

\*\*\* ONLY APPLICABLE ON D130-701-041 -IF  
 NOT USED, PLEASE MARK N/A \*\*\*

D2232-1 		Manufactured	No			100	Each	18.0000	2	2			
Basket Hinge													

Location	Loc Qty	Loc Code
WA	18	
55791	18	

D2327-1 		Manufactured	No			100	Each	17.0000	2	2			
Spacer Bushing													

Location	Loc Qty	Loc Code
WA	17	
54658	5	
60174	12	

W/O:		WORK ORDER CHANGES					
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Monday, November 29, 2010 3:30:46 PM

Page 3

Work Order ID: 64186

Parent Item: D2512

Parent Item Name: Basket Lid 205/350

Start Date: 11/29/2010

Required Date: 12/7/2010

Start Qty: 1.00

Required Qty: 1.00

M304EX0.75-16F

Purchased

No

100 sf

1,124.643

18

18.94737



SAD 10-12-01

Expanded Metal Flat SS

## Location

## Loc Qty

## Loc Code

MAT

1124.643833

114809

85.422943

114853

11.80059

115012

393.8315

115067

13.0125

115171

6.0394

115401

72.0095

115665

5.6216

115989

216.9058

116175

320

2.000

16.44737

M304TS0.750W.065

Purchased

No

100 f

1,189.168

43.5804

45.87411



SAD 10-12-01

304 SQ Tube .75x.75x.065W

## Location

## Loc Qty

## Loc Code

MAT

1089.43205

112398

0

115494

4.4725

115593

84.95955

116267

1000

WA

99.736185

115274

4.712185

115901

95.024

11.07545

34.59865

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Shop Packet Print

Page 3

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

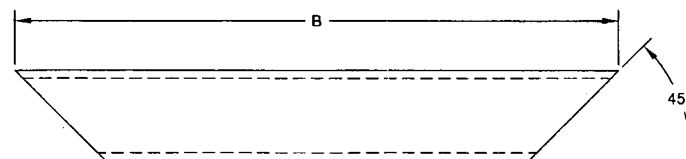
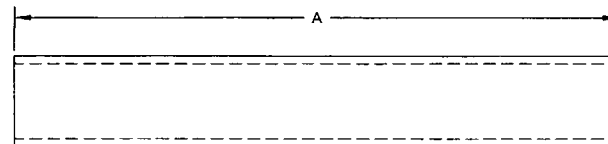
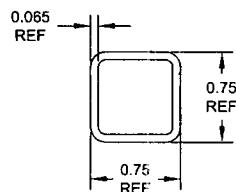
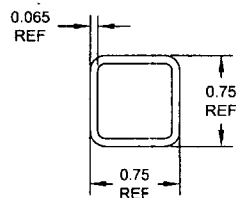
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# PARTS LIST FOR D2512 BASKET LID ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2512-1	2	—	25.50	RIB
D2512-3	2	—	95.30	RIB
D2512-5	6	30.84	—	RIB
D2512-7	3	30.63	—	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRACKET



E

## D2512-1/-3/-5/-7 NOTES:

- 1) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING  
REF. DART SPEC M304TS0.750W.065
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 64186  
B/10-11-25

RELEASED  
08-08-21/11

E	INCORPORATED D1 & D2. MATERIAL FOR -1, -3, -5, & -7 WAS 0.060 WALL. SHT 3 ZN C4 TOLERANCE REMOVED FROM 95.30 DIM. DRAWING TRANSFERRED TO 'B' FORMAT AND UPDATED TO CURRENT STANDARDS. SHT 3 VIEWS INVERTED FOR CLARITY. SHT 2 MESH MATERIAL CALLOUT UPDATED.	AJS	08.06.17
D	CHANGE HINGE	CP	01.04.19
C	REMOVE DOUBLE SKIN SECTION, ADDED MEMBERS, INCORP DEO 9074	DS	99.07.06
B	ADDED LATCH CHANNEL & LABEL PLATE	BW	96.05.24
A	NEW ISSUE	BW	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.		D2512 BASKET LID ASSEMBLY (350/212)	
DATE	08.06.17	REV. E	SHEET 1 OF 4
COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		SCALE	NTS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

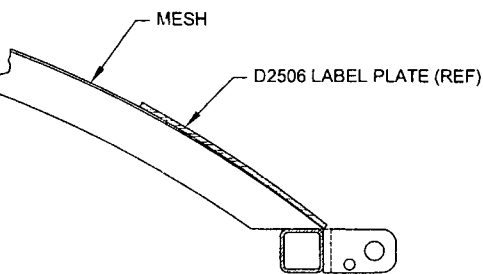
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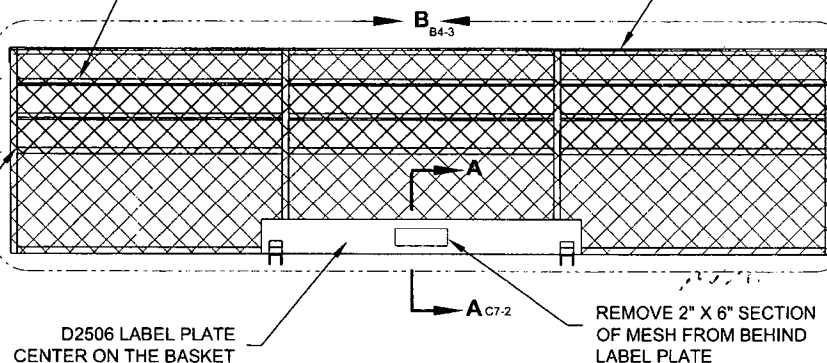
**SECTION A-A** B3-2  
(ROTATED 90° CCW)

FINISH THIS SECTION ALONG  
ENTIRE LENGTH PER NOTE 3  
AFTER POWDER COAT.

TACK WELD MESH TO FRAME  
AT EVERY AVAILABLE LOCATION  
IN AREA TO BE ANTI-SKIDDED

SKIN OUTSIDE SURFACE OF LID WITH  
3/4-16F EXPANDED SS. TACK WELD  
EACH END STRAND TO FRAME

SEE DETAIL B FOR  
FRAME ASSEMBLY

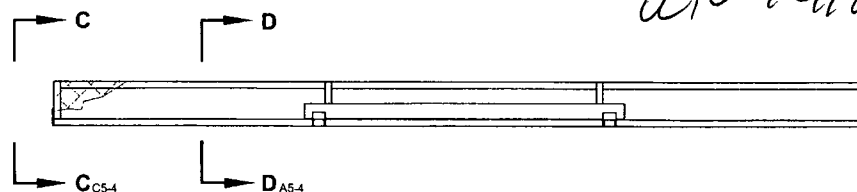


REMOVE 2" X 6" SECTION  
OF MESH FROM BEHIND  
LABEL PLATE



**D2512 BASKET LID ASSEMBLY NOTES:**

- 1) MESH MATERIAL: 3/4-16F EXPANDED SS  
REF DART SPEC M304EX0.75-16F
- 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) SPRAY PAINT BLACK INSIDE SURFACE  
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: N/A
- 9) WELD PER DART QSI 004



**RELEASED**  
08.05.21/17

DESIGN	BW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
DATE	08.06.17	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS TO BE USED ONLY FOR THE PURPOSES FOR WHICH IT WAS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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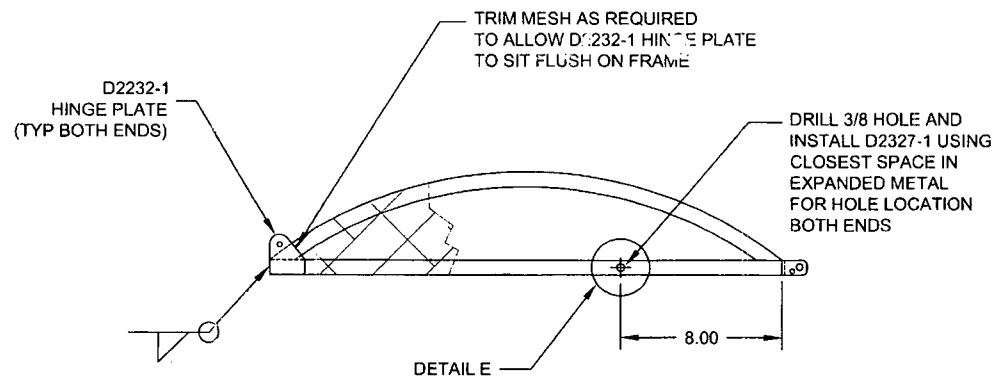
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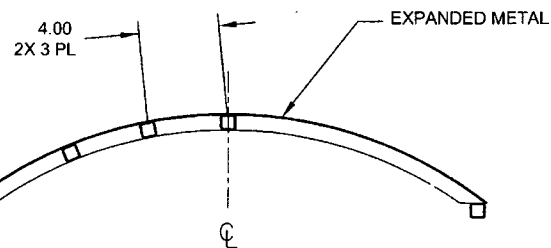
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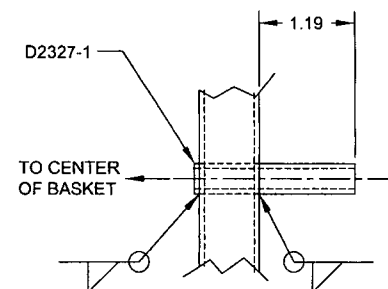
8 7 6 5 4 3 2 1



**VIEW C-C SIMILAR BOTH END RIBS** A5-2



**SECTION D-D SAME BOTH CENTER RIBS** A4-2



**DETAIL E** C6-4

*wloc4184*

**RELEASED**  
08-06-17

DESIGN	BW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
DATE	08.06.17	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

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